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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D117-762-011
Job Sheet 198649



Part No: D117-762-011

Job Qty: 1 pcs

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Due Date: 9/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI9771 REV A, IIN-D117-762 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA DD verified by:ec IPP Rev C 08.12.19 incorporated DSI9435 EC verified by:DD IPP REV:D 13.11.14 IIN REV.C DD VERF:JLM IPP REV:E 15.06.11 IIN REV.D DD VERF:JLM IPP REV:F 17.01.17 PER CHG004 (dsi9771) DD VERF:JLM IPP REV:G 17.08.16 PER CHG005 DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Packaging 1 - Pick Kit	1 pcs	9/12/19		0.00	0.00	Workcenter / Supplier Lead Time	
							Packaging 1 - 1	
							Packaging 1 - 2	
							Packaging 1 - 3	
							Packaging 1 - 4	NL
							Packaging 1 - 5	
							Packaging 1 - 6	
							Packaging 1 - 7	
							Packaging 1 - 8	
							Packaging 1 - 9	
							Packaging 1 - 10	
							Packaging 1 - 11	
							Packaging 1 - 12	
							Packaging 1 - 13	
							Packaging 1 - 14	
							Packaging 1 - 15	
							Packaging 1 - 16	
							Packaging 1 - 17	
							Packaging 1 - 18	
							Packaging 1 - 19	
							Packaging 1 - 20	
							Packaging 1 - 21	
							Packaging 1 - 22	
							Packaging 1 - 23	
							Packaging 1 - 24	
							Packaging 1 - 25	
							Packaging 1 - 26	
							Packaging 1 - 27	
							Packaging 1 - 28	
							Packaging 1 - 29	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S205885



Part: D117-762-011

Job No: 198649

Serial No/Batch: S205885

Revision: A / E

Inspector:

Exp Date:

Instructions: FAA STC SR01853SE 18/10/17, TC-STC LoA RDIMS-4374899 08/09

110 Packaging 1-1 - Pick Kit - B4B 1 pcs	9/12/19	0.00 0.00	Packaging 1 - 30	
			Packaging 1 - 31	
			Packaging 1 - 32	
			Packaging 1 - 33	
			Packaging 1 - 34	
			Packaging 1 - 35	
			Packaging 1 - 36	
			Packaging 1 - 1 - B4B	MKD 8/28/2019
			Packaging 1 - 2 - B4B	
			Packaging 1 - 3 - B4B	
			Packaging 1 - 4 - B4B	
			Packaging 1 - 5 - B4B	
			Packaging 1 - 6 - B4B	
			Packaging 1 - 7 - B4B	
			Packaging 1 - 8 - B4B	
			Packaging 1 - 9 - B4B	
			Packaging 1 - 10 - B4B	
			Packaging 1 - 11 - B4B	
			Packaging 1 - 12 - B4B	
			Packaging 1 - 13 - B4B	
			Packaging 1 - 14 - B4B	
			Packaging 1 - 15 - B4B	
			Packaging 1 - 16 - B4B	
			Packaging 1 - 17 - B4B	
			Packaging 1 - 18 - B4B	
			Packaging 1 - 19 - B4B	
			Packaging 1 - 20 - B4B	
			Packaging 1 - 21 - B4B	
			Packaging 1 - 22 - B4B	
			Packaging 1 - 23 - B4B	
			Packaging 1 - 24 - B4B	
			Packaging 1 - 25 - B4B	
			Packaging 1 - 26 - B4B	
			Packaging 1 - 27 - B4B	
			Packaging 1 - 28 - B4B	
			Packaging 1 - 29 - B4B	
			Packaging 1 - 30 - B4B	
			Packaging 1 - 31 - B4B	
			Packaging 1 - 32 - B4B	
			Packaging 1 - 33 - B4B	
			Packaging 1 - 34 - B4B	
			Packaging 1 - 35 - B4B	
			Packaging 1 - 36 - B4B	
120 QC 4 1 pcs	9/12/19	0.00 0.00	QC 4 - 28	
			QC 4 - 58	
			QC 4 - 69	
			QC 4 - 9	
			QC 4 - 46	
			QC 4 - 68	
			QC 4 - 72	
			QC 4 - 74	
			QC 4 - 75	
130 Packaging 3-1 - Stock - B4B 1 pcs	9/12/19	0.00 0.00	Packaging 3 - 1 - B4B	Max B DAS 75 9-89
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	9/12/19	0.00 0.00	DC - 1 - B4B	21	AUG 28 2019
				DC - 2 - B4B	21	
140 QC 21 - FG	1 pcs	9/12/19	0.00 0.00	QC 21 - FG - 21	21	AUG 28 2019
				QC 21 - FG - 70	21	
				QC 21 - FG - 53	9-89	

Part Op 120 - QC4- 100% Inspect kits for completeness
Descriptions: 130 - Identify and pack for shipping as per PPP D117-762-011 Location :FG081
135 - Document Control - Photocopy bluefile & type labels per PPP D117-762-011 CHG005
140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
AN6C52A	Bolt	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	S201294
D3512-041	Wearplate	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	D133240
D5300-1	GHL Bushing	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	S111352
D5301-1	GHL Plug	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	S110986
MS21043-6	Nut	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	S203269
D117-762-041	Replacement Skidtube	1 pcs (1 ea)	110-Packaging 1-1 - Pick Kit - B4B	S206844

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	AN6C52A	2	60	0
	D3512-041	2	4	0
	D5300-1	2	38	0
	D5301-1	2	30	0
	MS21043-6	2	91	0
110-Packaging 1-1 - Pick Kit - B4B	D117-762-041	1	0	0

Part Specifications
Specifications could not be found.

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NCR No. _____		Job: _____		DISPOSITION		DEPARTMENT/PROCESS									
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)											
Description Work Order Deviation				Disposition											
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY											
				Pressure/Forced			Contamination			Power Loss/Surge			Positioned Wrong		
				Bending			Misaligned/off center			Folio/Program			Outside Tolerance		
				Crushing			BOM/Route			Grain Direction			Drawing		
				Cracks			Broken/Damage/Defect			Weld			Finish		
Crimp/Kink/Ripple/Wave/Twist			Incomplete/Unclear Instructions			Wrong Stock Pulled			Part Lost/Missing						
Marks/Chatter			Drill Holes			Out of Sequence			Misread						
Mislabeled			Fit/Function			Off-set/Set-up									
Other/Details:															
Completed By				Lead hand / Supervisor											
QC / QA Coordinator															

5.0PARTS LIST

5.1 D117-762-011 Skidtube Parts List

Item	Qty -011	Qty -041	Part Number	Description
	X		D117-762-011	SKIDTUBE INSTALLATION
	1	X	D117-762-041	REPLACEMENT SKIDTUBE
1		1	D3582-041	SKIDTUBE ASSEMBLY
2	2		**1121-51002	SKID SHOE
3	2		**1121-51102	CLAMPING RING
4	8		**LN9380M8X45	HEXAGON BOLT
5	8		**LN9023A8-1.4544.9	LOCKING WASHER
6	8		**LN9025-0815K	WASHER (OR LN9025-0815L)
10		1	*D2965	CAP
11		2	***AELS-1032-225	INSERT
12		2	*AN3C5A	BOLT
13		2	*NAS1149C0332R	WASHER (OR AN980C10L)
20A		1	*D3508-9	WEARPLATE
20B		1	*D3558-9	GASKET
21A		1	*D3508-3	WEARPLATE
21B		1	*D3558-3	GASKET
22A		1	*D3508-11	WEARPLATE
22B		1	*D3558-11	GASKET
23A		1	*D3508-13	WEARPLATE
23B		1	*D3558-13	GASKET
24		36	*AELS-1032-130	INSERT
25	8	28	*AN3C4A	BOLT
26	8	28	*NAS1149C0332R	WASHER (OR AN960C10L)
27	2		D3512-041	WEARPLATE
30		2	*AELS-1032-130	INSERT
31		2	*AN3C4A	BOLT
32		2	*NAS1149C0332R	WASHER (OR AN960C10L)
50	2		AN6C51A	BOLT
51	4		D3864-1	BUSHING
52	2		MS21043-6	NUT

* PART IS INCLUDED WITH D3582-041 SKIDTUBE ASSEMBLY
** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY
*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-762 REV. E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-762 REV. 4

REF FAA STC: SR01853SE
REF: TC LETTER OF ACCEPTANCE RDIMS-4374899
REF EASA STC: EASA.10017063

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to replace the ground handling lugs (D3864-1 Bushings, AN6C51A Bolts and MS21043-6 Nuts) on the D117-762-XXX Skidtubes with a structurally superior lug design (D5300-1 Bushings, D5301-1 Plugs, AN6C52A Bolts, MS21043-6 Nuts) as shown in Figure 1. The new hardware will be included in D117-762-011 @ CHG 004 and subsequent.

2.0 INSTALLATION

For D117-762-011 @ CHG 004 and subsequent, the ground handling hardware should be installed as follows:

- 2.1 Loosely install (qty 2) D5300-1 GHL Bushing & (qty 2) D5301-1 GHL Plug wet with Proseal 890 or MIL-S-8802 Class B2 Sealant in location shown in Figure 1.
- 2.2 Install (qty 2) AN6C52A Bolts and (qty 2) MS21043-6 Nuts in accordance with Figure 1. Clean up squeezed out Proseal and apply fillet seal around D5300-1 & D5301-1.
- 2.3 Torque AN6C52A Bolts 160 - 190 in-lbs (18.1 - 21.5 N-m).

3.0 PARTS LIST

For D117-762-011 @ CHG 004 and subsequent, the Part List in IIN-D117-762 and ICA-D117-762 is modified as follows:

IS

ITEM	QTY -011	PART NUMBER	DESCRIPTION
	X	D117-762-011	SKIDTUBE INSTALLATION
50	2	AN6C52A	BOLT
51A	2	D5300-1	GHL BUSHING
51B	2	D5301-1	GHL PLUG
52	2	MS21043-6	NUT

A	NEW ISSUE	RF	17.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE, LTD EUGENE, OR	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV.A
MFG. APPR.	N/A	DSI 9771	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.		GHL UPGRADE KIT	NTS
DATE	17.01.09	COPYRIGHT ©2017 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, LTD.	

WAS

ITEM	QTY -011	PART NUMBER	DESCRIPTION
	X	D117-762-011	SKIDTUBE INSTALLATION
50	2	AN6C51A	BOLT
51	4	D3864-1	BUSHING
52	2	MS21043-6	NUT

4.0 WEIGHT AND BALANCE

There is negligible weight and balance change associated with this modification.

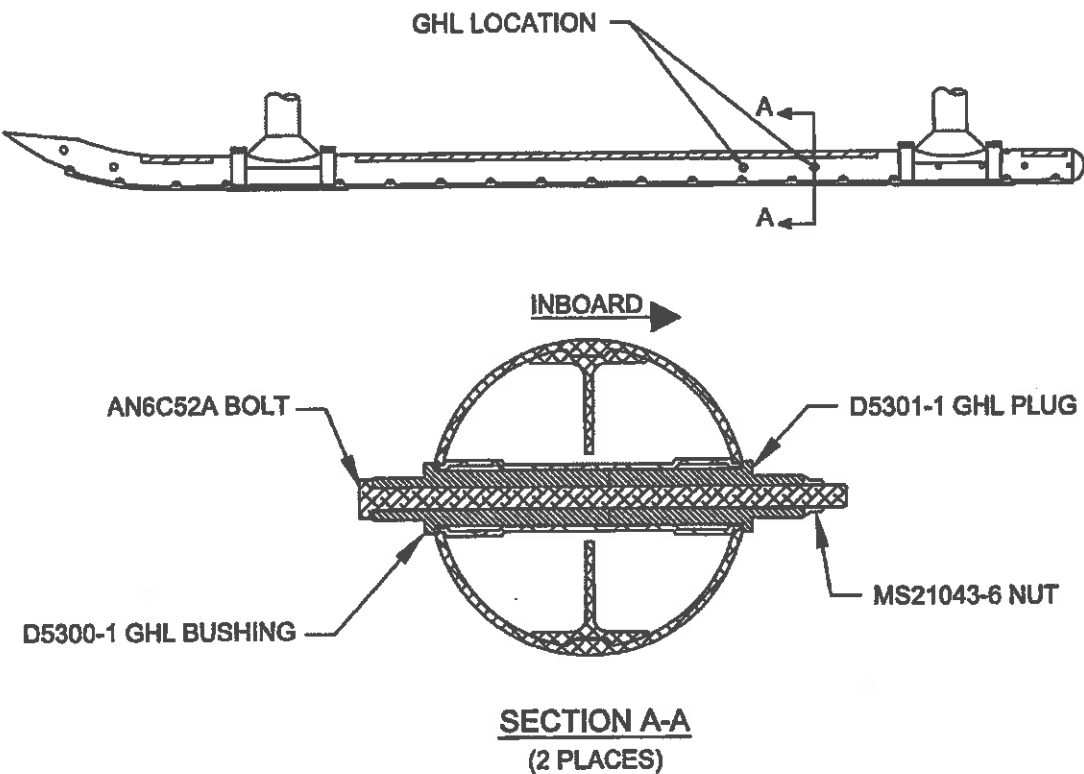


FIGURE 1 - GHL UPGRADE INSTALLATION

DESIGN	RF	DART AEROSPACE, LTD EUGENE, OR	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV.A
MFG. APPR.	N/A	DSI 9771	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.		GHL UPGRADE KIT	NTS
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Michelle GagnonDonovan

From: Shipping
Sent: Wednesday, August 28, 2019 12:49 PM
To: Michelle GagnonDonovan
Subject: Red Label

Hi Michelle,

please provide a red label for order

D117-762-011
198649
s205885

Thanks
Max

Change Record

PAGE 1 OF 1

Part Number: D117-762-011Description: SKIDTUBE[illegible]